

LUSH

Date: Thursday, 1/25/2007 10:21:54 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG WELDMENT
Job Number	: 30459		
Estimate Number	: 11872		
P.O. Number	: <i>N/A</i>	Part Number	: D33539
This Issue	: 1/25/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3353 REV.A
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 30179	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 2/1/2007
Checked & Approved By	: <i>[Signature]</i> 07.01.25	Qty:	8 Um: Each
Comment	: rev est. A 06.01.14 New issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B0375X01500	1010-1025 BAR
-----	------------------	---------------



Comment: Qty.: 0.1092 f(s)/Unit Total: 0.8736 f(s)
1010-1025 BAR
AISI 1010-1025 Steel bar 0.375" x 1.00"

batch: *M15925* *BC/DJP 07/01/27* *(16)*

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
1-Cut blanks 1.10" long

BC/DJP 07/01/27 *(16)*

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE
1- Mill angle as per dwg D3353

2-Grind corner radius as per dwg D3353

3- Deburr

BC/DJP 07/01/27 *(16)*

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

07/01/27 *(16)*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

07/01/27 *(16)*

can

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/25/2007 10:21:55 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 30459

Part Number: D33539

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



16

Comment: FINAL INSPECTION/W/O RELEASE

07/01/29

Job Completion



U 07-06-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: IP Date: 07/01/29
 QA: N/C Closed: _____ Date: _____

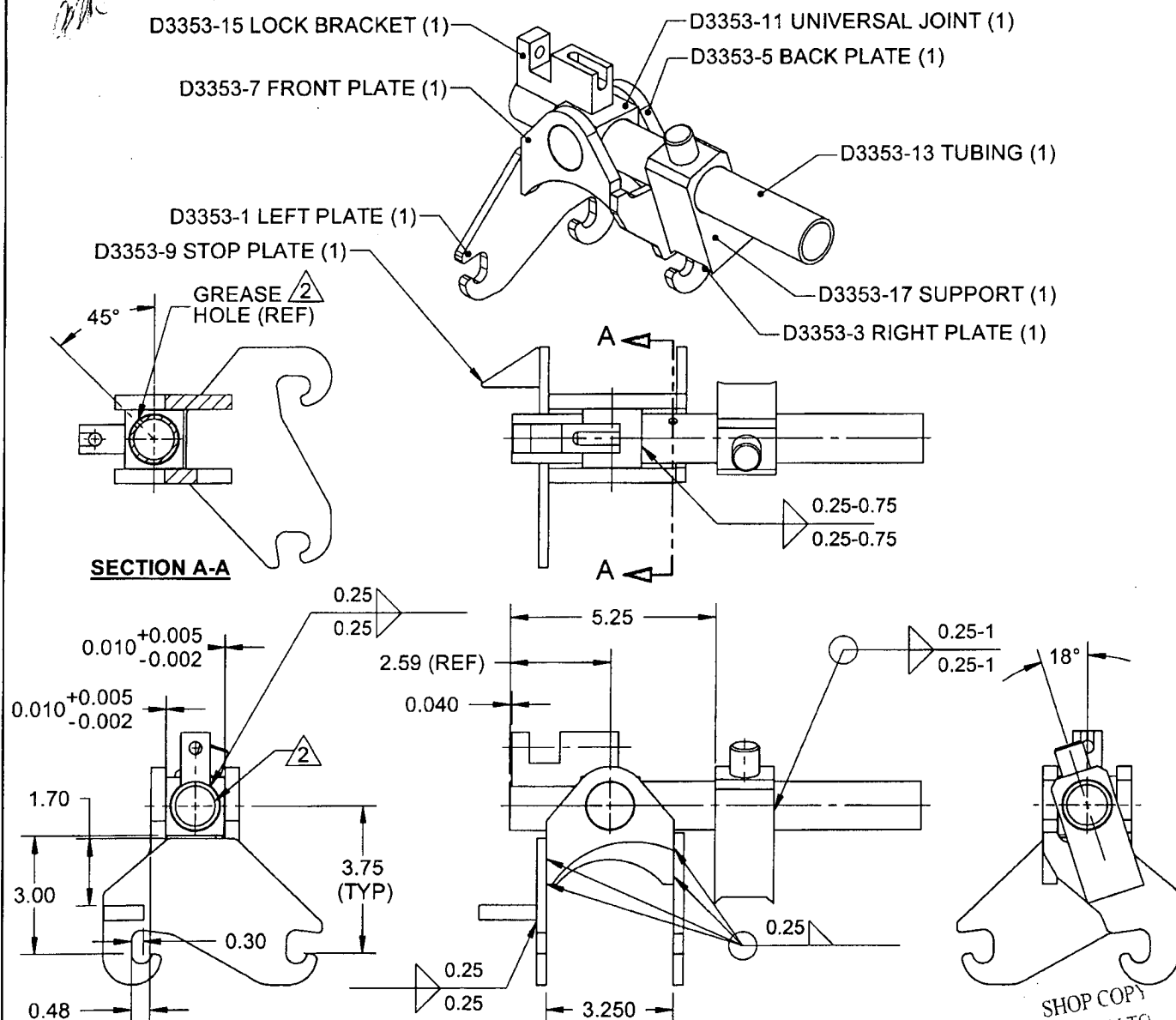
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:4
A	04.12.14	NEW ISSUE	

RELEASED
[Signature]



D3353-041 LUG WELDMENT

NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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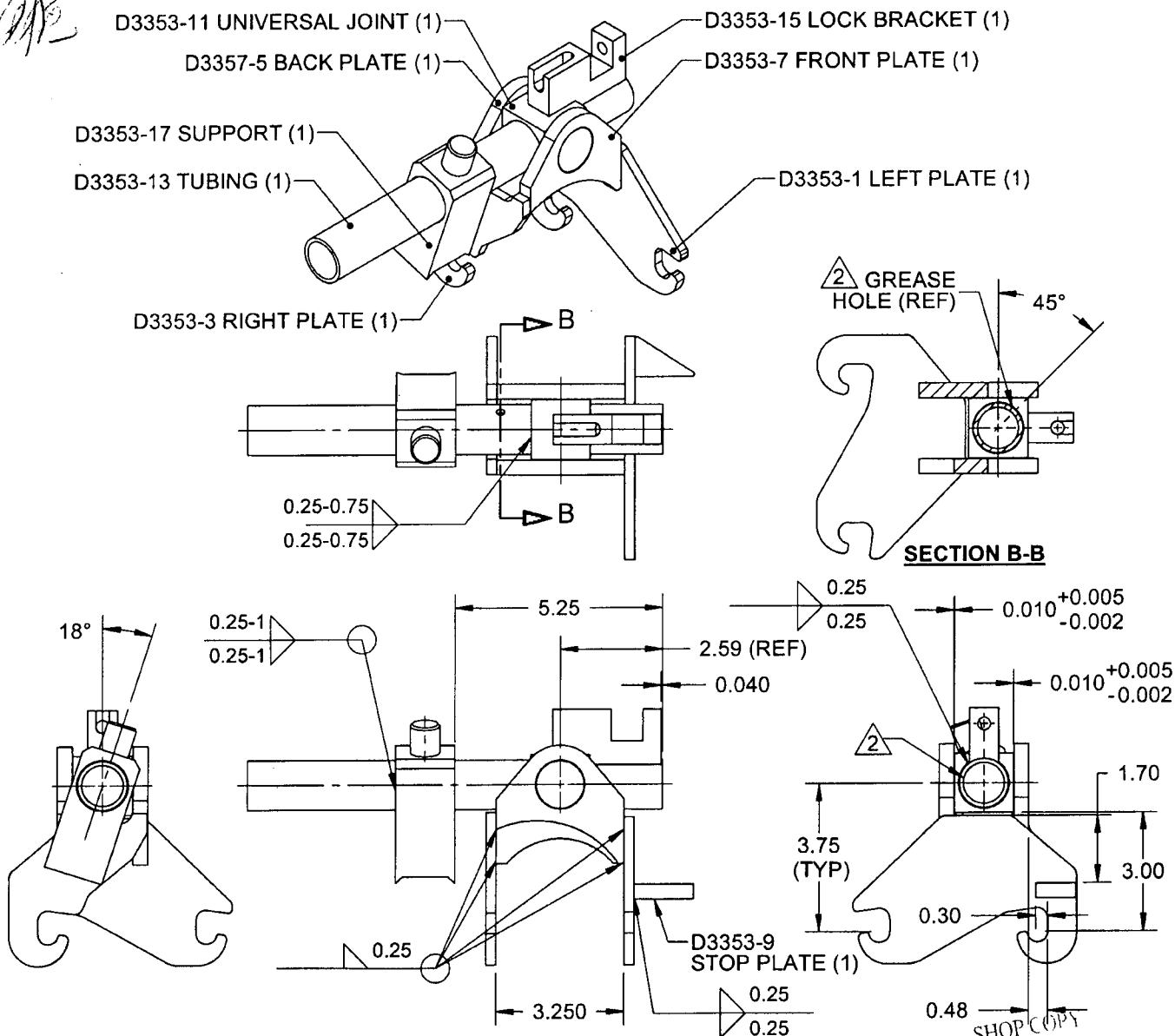
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:4

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04/16/59



D3353-042 LUG WELDMENT

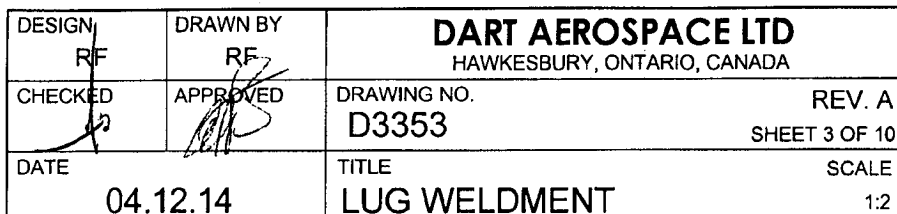
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- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

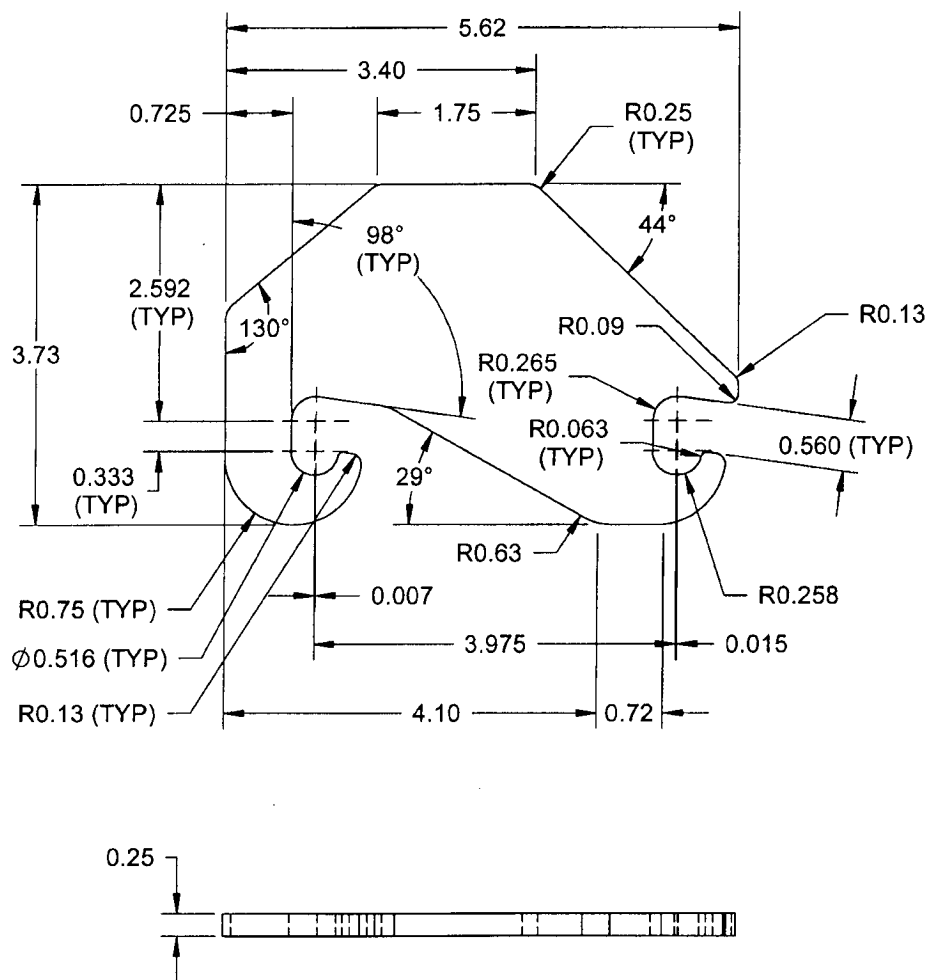
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06/07/64



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250" THICK)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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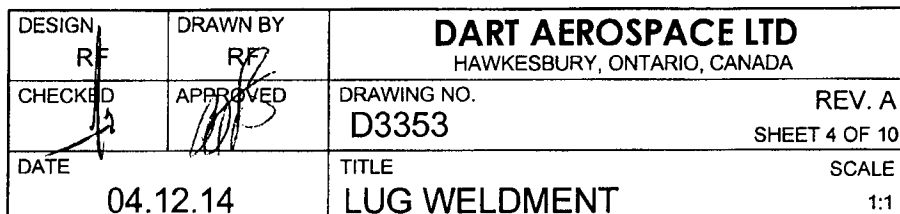
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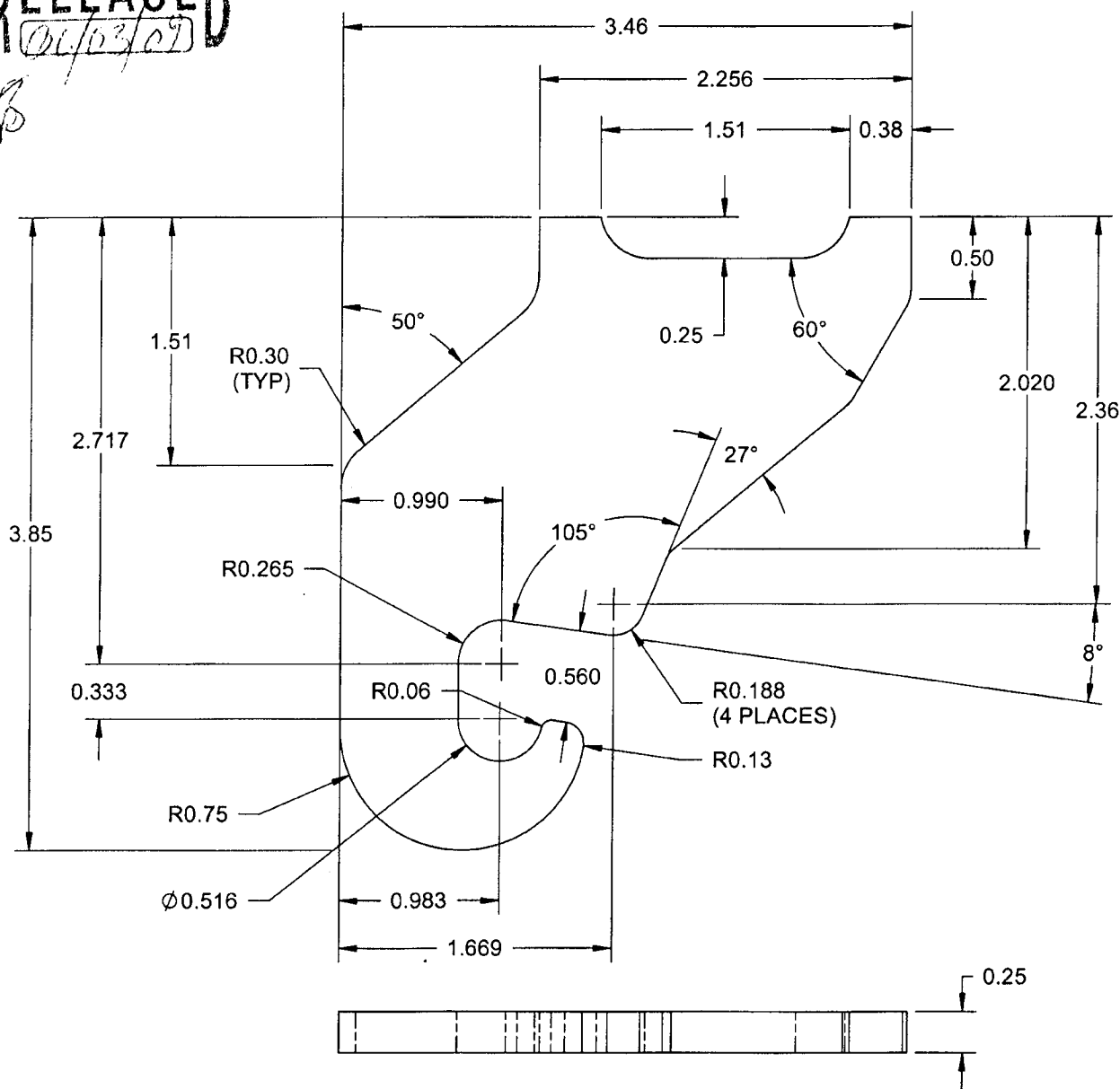
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2010/03/09



D3353-3 RIGHT PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21,
38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

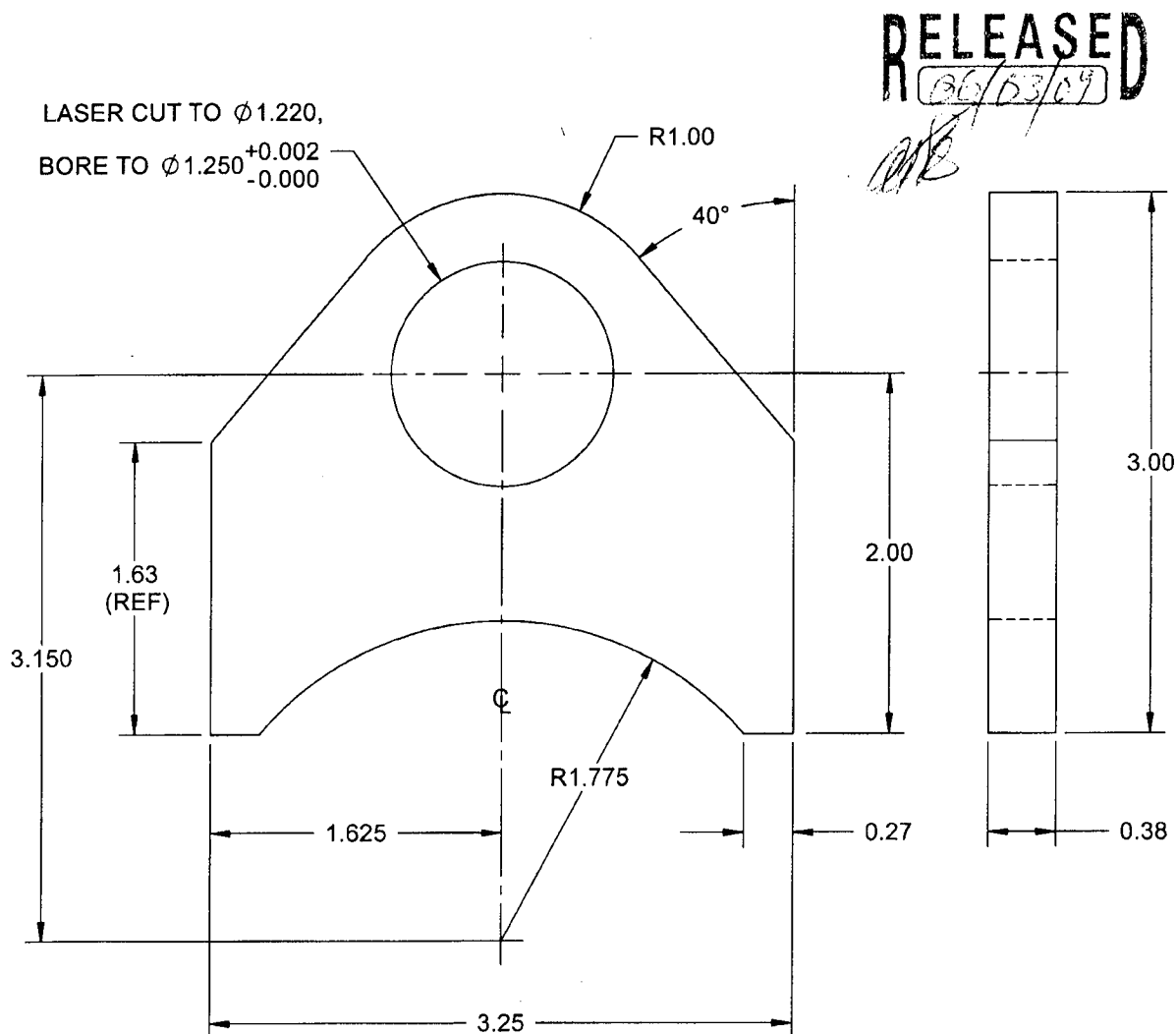
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1



D3353-5 BACK PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

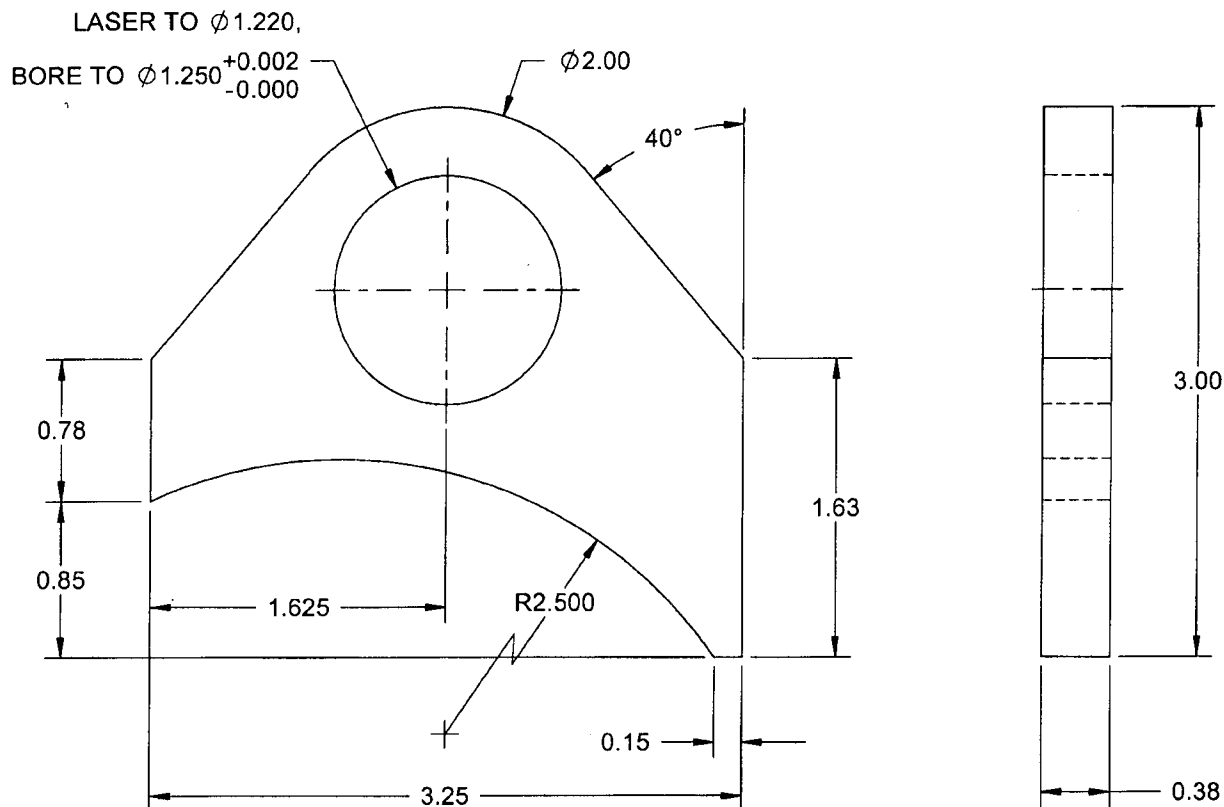
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DATE 04.12.14		TITLE LUG WELDMENT	SHEET 6 OF 10 SCALE 1:1

RELEASED
06/06/17**D3353-7 FRONT PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

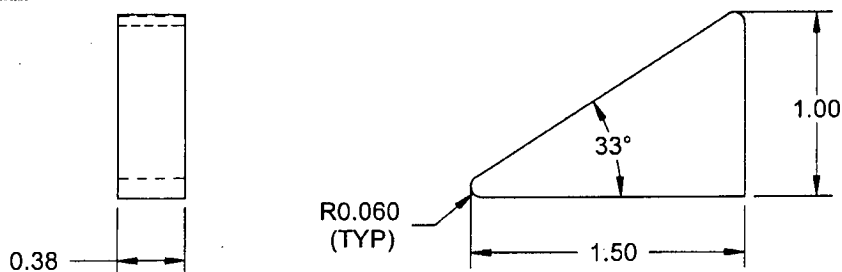
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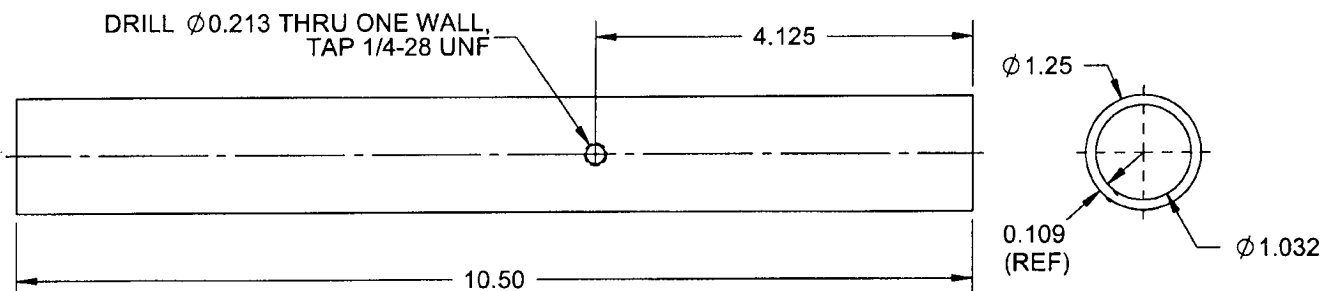
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

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3/3/04*ME***D3353-9 STOP PLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR
CSA G40.21, 38W/44W/50W/60W/70W, 0.375 THICK
MILD STEEL BAR (REF. DART SPEC. M1010-B)

**D3353-13 TUBING****NOTES:**

- 1) MATERIAL: MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077,
Ø1.250 x 0.125 WALL, COLD DRAWN STEEL TUBING
(REF. DART SPEC. M1020TR1.250W.109)

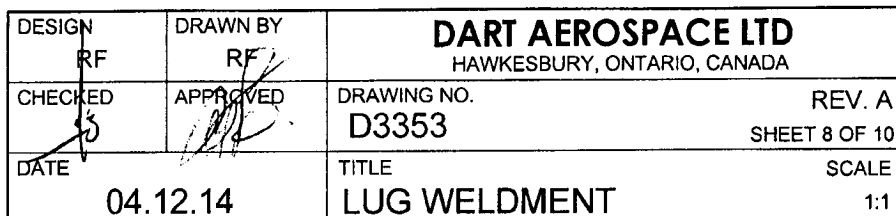
NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

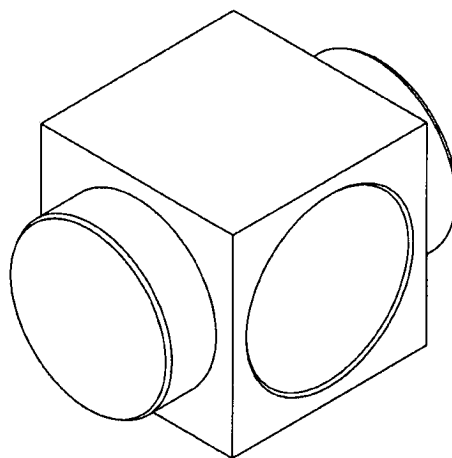
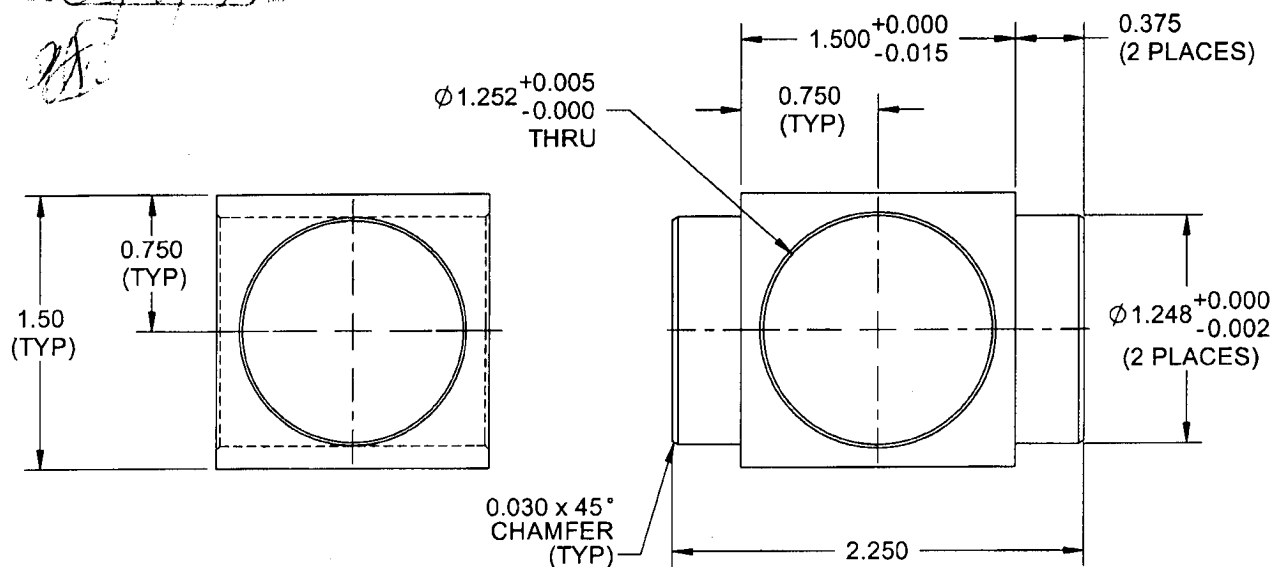
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06/30/09



D3353-11 UNIVERSAL JOINT

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR
CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD
STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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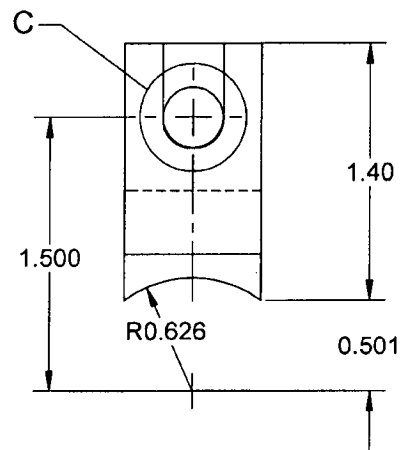
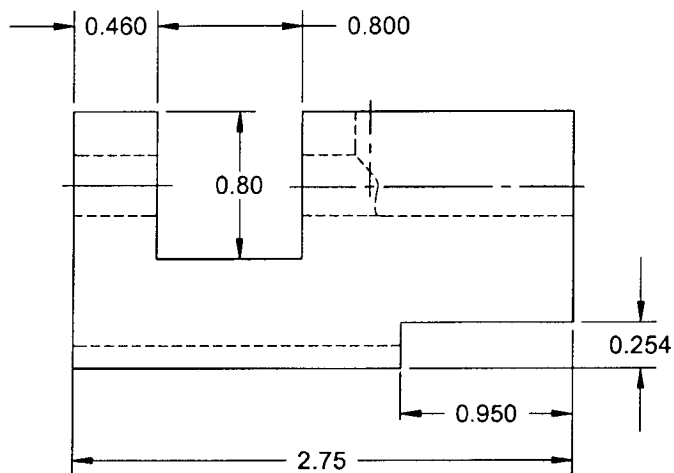
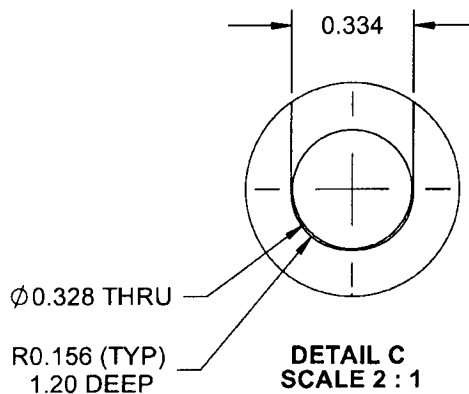
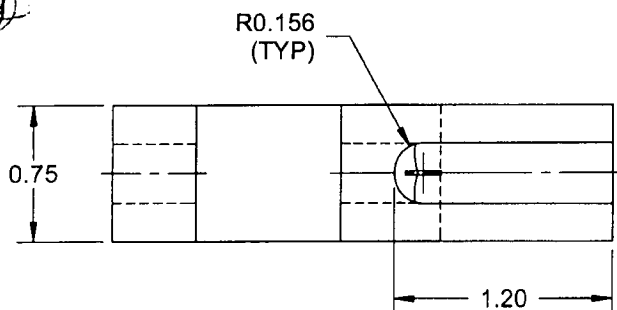
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

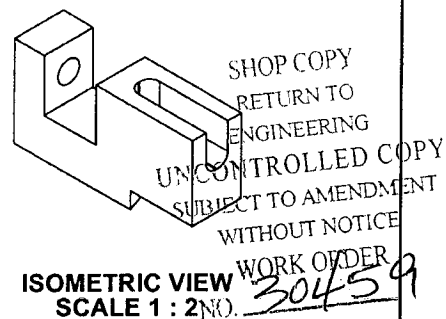
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06/02/09



D3353-15 LOCK BRACKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

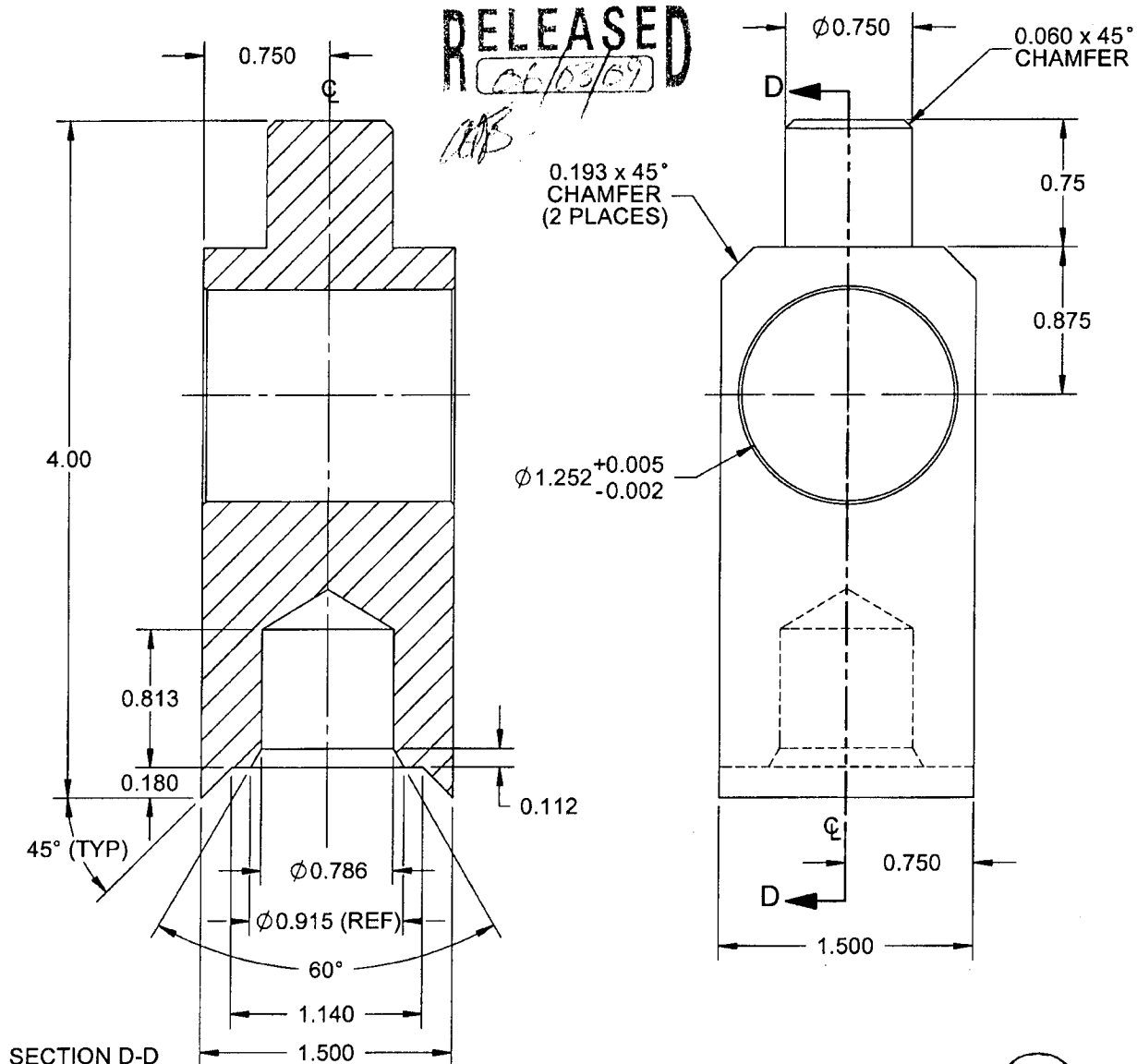


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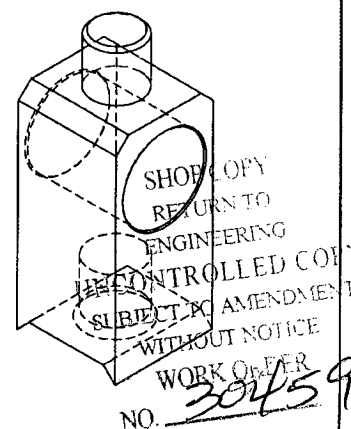
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

**D3353-17 SUPPORT****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B1.500x01.500)
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